

Work Order ID 133978

Tuesday, June 23, 2015 3:26:20 PM

133978

Page 1

Item ID: D4149-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft X-Tube Lug Ass'Y
 Start Date: 6/23/15 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/23/15 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: JUN 24 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4149	C

100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	Identify as per dwg & Stock Location: <u>SL539</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

DAS
36
9-89

DAS
38
9-89
JUL 28 2015

⑧ DAS
27
9-89
JA JUL 28 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Item ID: D4149-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Aft X-Tube Lug Ass'Y
Start Date: 6/23/15 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 6/23/15 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

15/7/30

SA 20150730

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 133978

133978

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 6/23/15

Required Date: 6/23/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	990.0000	4	16			DAS
MS21043-3									**			15/06/24	36 9-89

Nut

Location	Loc Qty	Loc Code
FG	80	
103691	80	
FP001	17	
m130673	17	
GA	229	
m130673	15	
m131677	214	16
ST304	264	
m131340	199	
m132382	65	
ST308	400	
m132551	400	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Work Order ID: 133978

133978

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 6/23/15

Required Date: 6/23/15

Start Qty: 8.00

Required Qty: 8.00

MS21043-4

Purchased

No

100

Each

980.0000

1

24

MS21043-4

Nut

DAS
36
9-89

15/06/24

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

240

m128798

240

ST260a

400

m132536

400

ST304

300

m128818

34

m131697

9

m132382

257

24

D3910-1

Manufactured

No

100

Each

5.0000

1

8

D3910-1

Crosstube Lug

DAS
36
9-89

15/06/24

Location

Loc Qty

Loc Code

ST524

5

128844

5

5

B133421 (3x)

D4091-1

Manufactured

No

100

Each

26.0000

1

8

D4091-1

Mounting Lug

DAS
36
9-89

15/06/24

Location

Loc Qty

Loc Code

ST522

26

132509

26

8

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	☐	Past Due ☐																							

Picklist Print

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Work Order ID: 133978

133978

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 6/23/15

Required Date: 6/23/15

Start Qty: 8.00

Required Qty: 8.00

D4149-1 Manufactured No

100 Each 16.0000 2 16

D4149-1

Crosstube Lug Plate, Aft

**

DAS
36
9-89

15/06/24

Location

Loc Qty

Loc Code

ST094

16

125697

1

132670

3

133477

12

3
12

13133970 (12)

D4149-3 Manufactured No

100 Each 10.0000 1 8

D4149-3

Spacer

**

DAS
36
9-89

15/06/24

Location

Loc Qty

Loc Code

ST094

10

132623

10

8

D4149-5 Manufactured No

100 Each 12.0000 1 8

D4149-5

Eyebolt Stud

**

DAS
36
9-89

15/06/24

Location

Loc Qty

Loc Code

ST103a

12

122937

4

130604

2

132501

6

26

AN3C12A Purchased No

100 Each 176.0000 2 16

AN3C12A

Bolt

**

DAS
36
9-89

15/06/24

Location

Loc Qty

Loc Code

GA

101

M128727

101

ST349

75

M128727

75

76
16

Tuesday, June 23, 2015 3:26:20 PM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																								

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Work Order ID: 133978

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Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 6/23/15

Required Date: 6/23/15

Start Qty: 8.00

Required Qty: 8.00

AN4C13A	Purchased	No	100	Each	37.0000	3	24	DAS
AN4C13A								36
BOLT								9-89

**

15/06/24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST344	37	
m128818	8	
m132344	29	

24

MS20615-4M18	Purchased	No	100	Each	370.0000	3	24	DAS
MS20615-4M18								36
Rivet								9-89

**

15/06/24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CCK003	370	
m123810	370	

24

NAS1149C0332R	Purchased	No	100	Each	5,176.000	4	32	DAS
NAS1149C0332R								36
WASHER								9-89

**

15/06/24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	2140	
m130325	2140	
GA	318	
m131618	318	
ST271	2718	
m132262	2718	

32

DQA: _____ Date: _____



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Picklist Print

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Tuesday, June 23, 2015 3:26:20 PM

Work Order ID: 133978

133978

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 6/23/15

Required Date: 6/23/15

Start Qty: 8.00

Required Qty: 8.00

NAS1149C0432R

Purchased

No

100

Each

2,355.000

6

48

NAS1149C0432R

15/06/24

DAS
36
9-89

WASHER

Location

Loc Qty

Loc Code

GA

2004

m125807

476

m131467

1528

ST271

351

m131452

351

48

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : 					